

Work Order ID 58138

April 26, 2010 11:11:13 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4095-043

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Wearplate Assembly

Start Date: 4/26/10 Start Qty: 2.00

Cust Item ID:

Required Date: 4/26/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

PA3

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-04-26

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to inner surface of waerplate as per dwg
A/R 3M Scotch grip adhesive Batch:

M113174

100426

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10-04-26

Page 2

Accept

**Setup Start**

Year	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099																																																																																																																																																																																																																																									
1991	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	

Stop



1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve research, consultation with experts, or reviewing existing data.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of actions to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks identified in the plan and monitoring progress as the work progresses.

5. The fifth step is to evaluate the results. This involves comparing the outcomes of the work against the original objectives and identifying any areas for improvement.

6. The sixth step is to communicate the findings. This involves sharing the results of the work with the relevant stakeholders and providing a clear summary of the findings.

7. The seventh step is to reflect on the process. This involves considering what worked well, what challenges were encountered, and how the process could be improved for future tasks.

8. The eighth step is to document the results. This involves creating a record of the work done, the findings, and the conclusions drawn, which can be used for future reference.

9. The ninth step is to review the overall process. This involves looking at the entire process from start to finish and identifying any key lessons learned.

10. The tenth step is to conclude the project. This involves finalizing all tasks and ensuring that all objectives have been met.

Cust Item ID:
Customer:

Reference:

Run Start



Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop

Abstract

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	Memo	0.00	SABY					10-04-2
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							10/10/07
	QC	Memo	0.00						mrf
	Quality Control								

10/10/07 *HA*
mf
10-A-2

POSITIVE RECALL
EFFECTIVE 10/10/07 AUTH 6
RELEASED DATE 10.10.07

April 26, 2010 11:11:12 AM

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Required Date: 4/26/10

Required Qty: 2.00

[illegible]

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

D4095-1
WEARPLATE

△ D4095-041 WEARPLATE ASSEMBLY

D4096-1
GASKET 8

D4096-3
GASKET 8


D4095-3
WEARPLATE

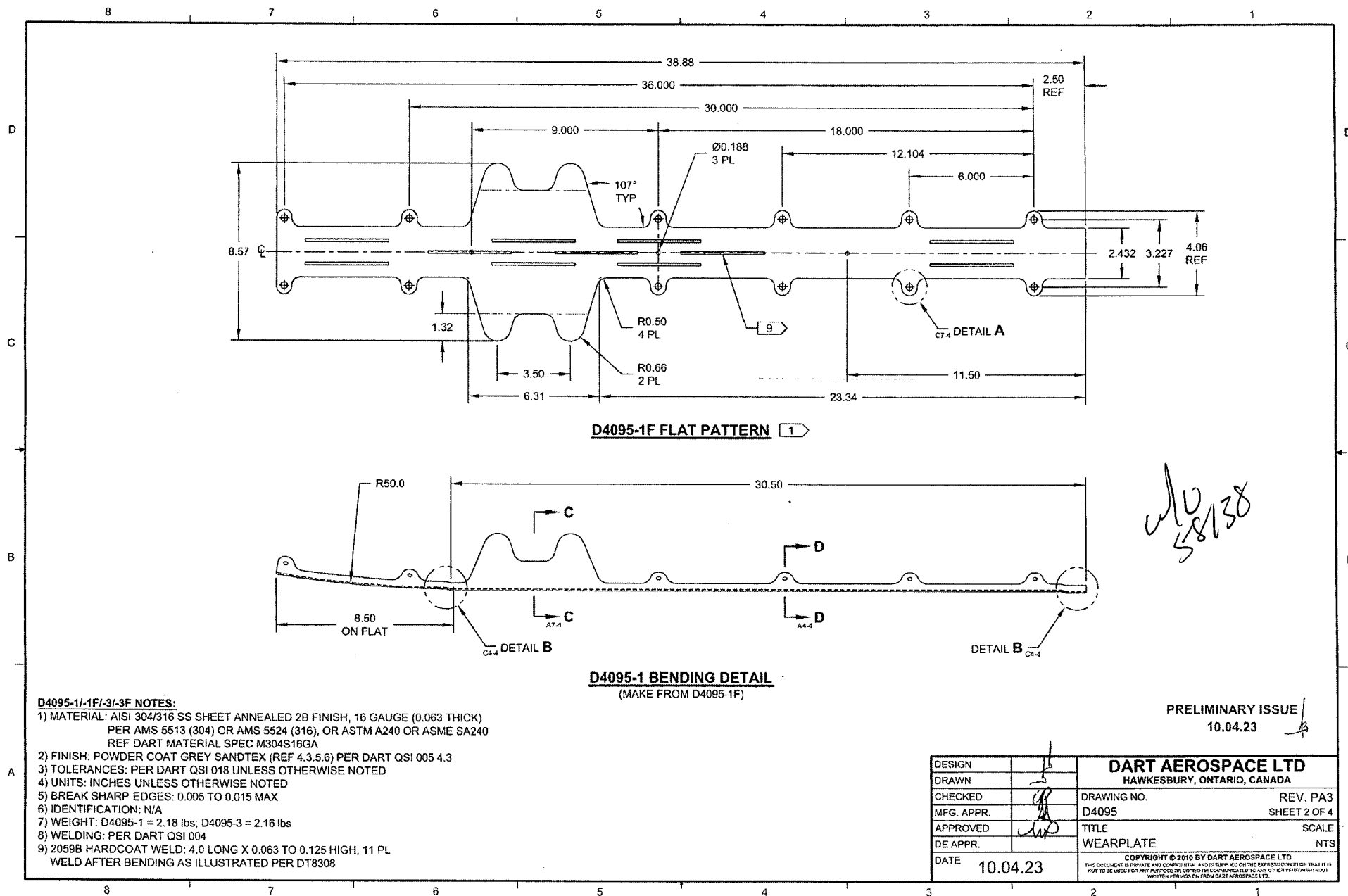
△ D4095-043 WEARPLATE ASSEMBLY

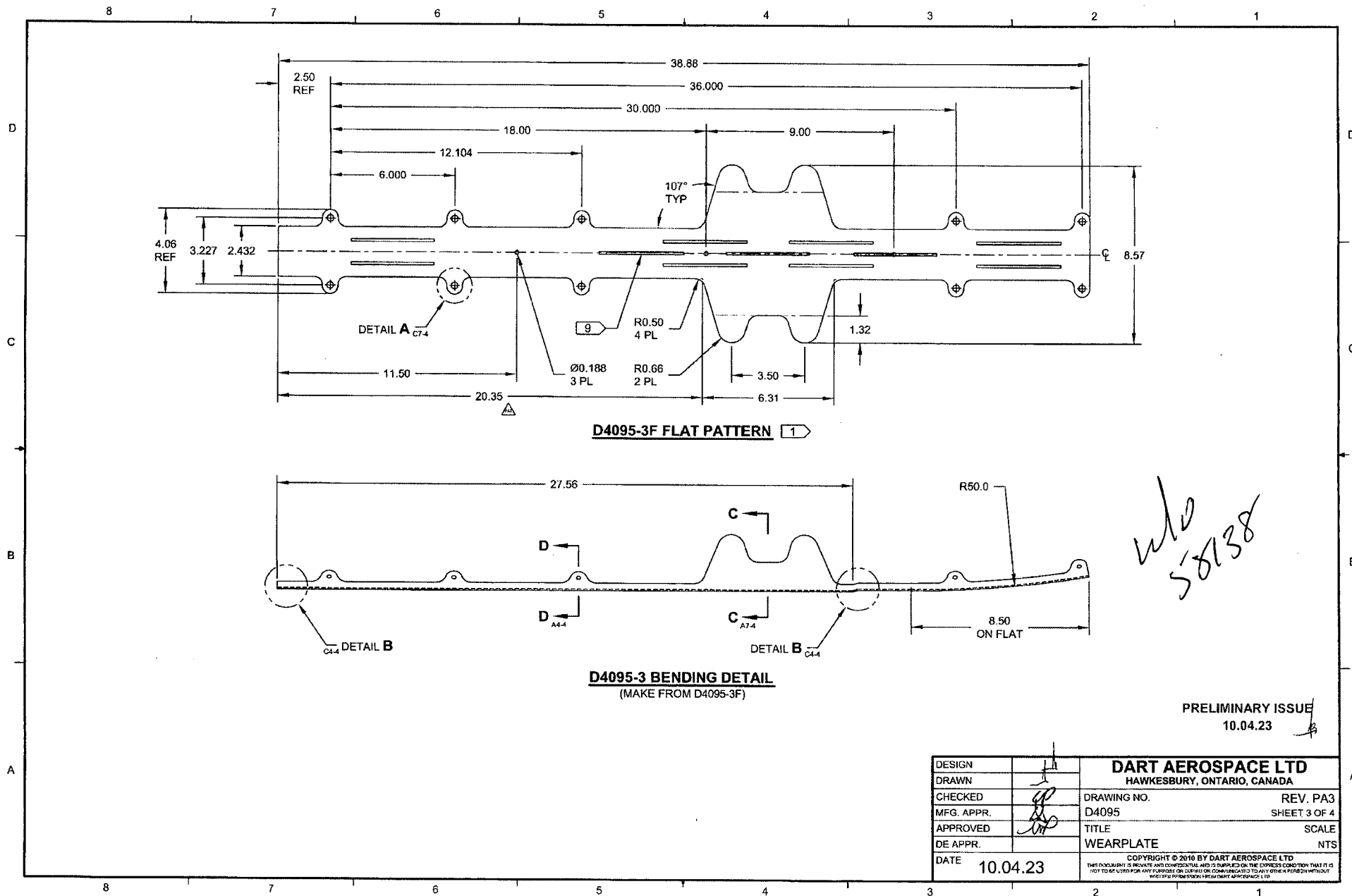
PRELIMINARY ISSUE
10.04.23

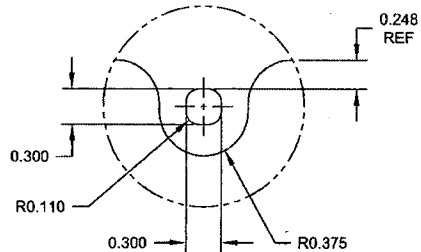
D4095-041/-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

PA3	ADDED D4095-041/-043; 20.35 WAS 20.69 (ZN C6-3); DIM 2.80 REF WAS 2.72 (ZN B6-4)	MB	10.04.23
PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. PA3
CHECKED		D4095	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.			
DATE		10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>

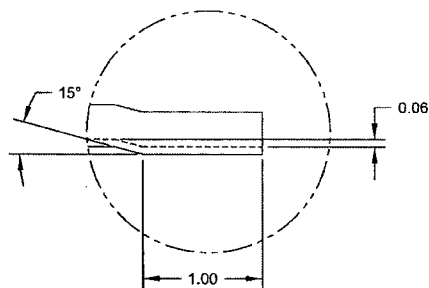






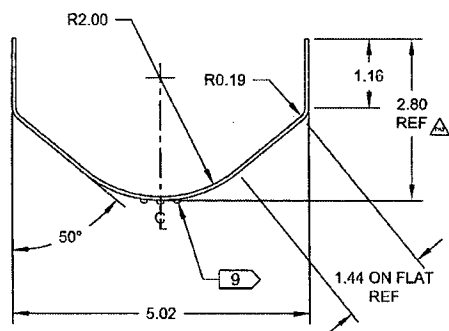
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SCALE 4X
C3-2
C6-3



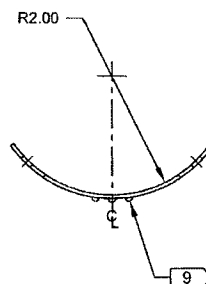
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-2
B6-2
B4-3
B7-3



SECTION C-C

SCALE 2X
B5-2
B4-3



SECTION D-D

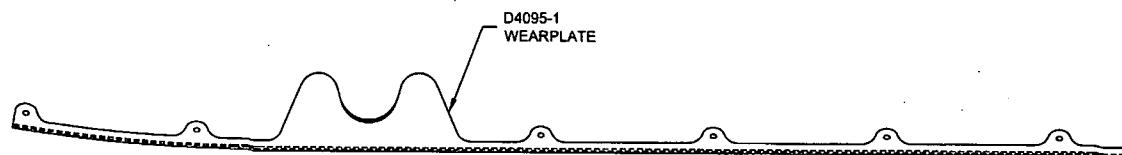
SCALE 2X

58138

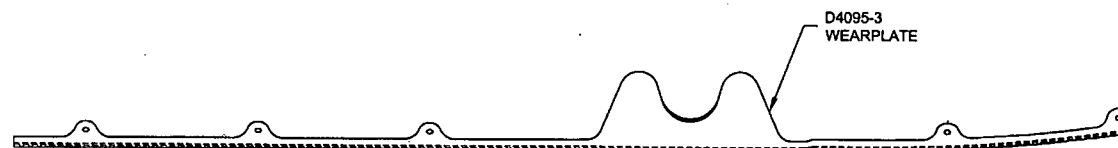
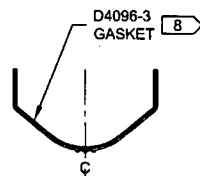
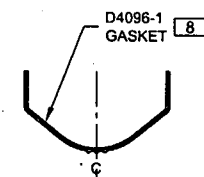
PRELIMINARY ISSUE
10.04.23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY

58138

RELEASED
2010-09-07
JW

D4095-041/-043 NOTES:

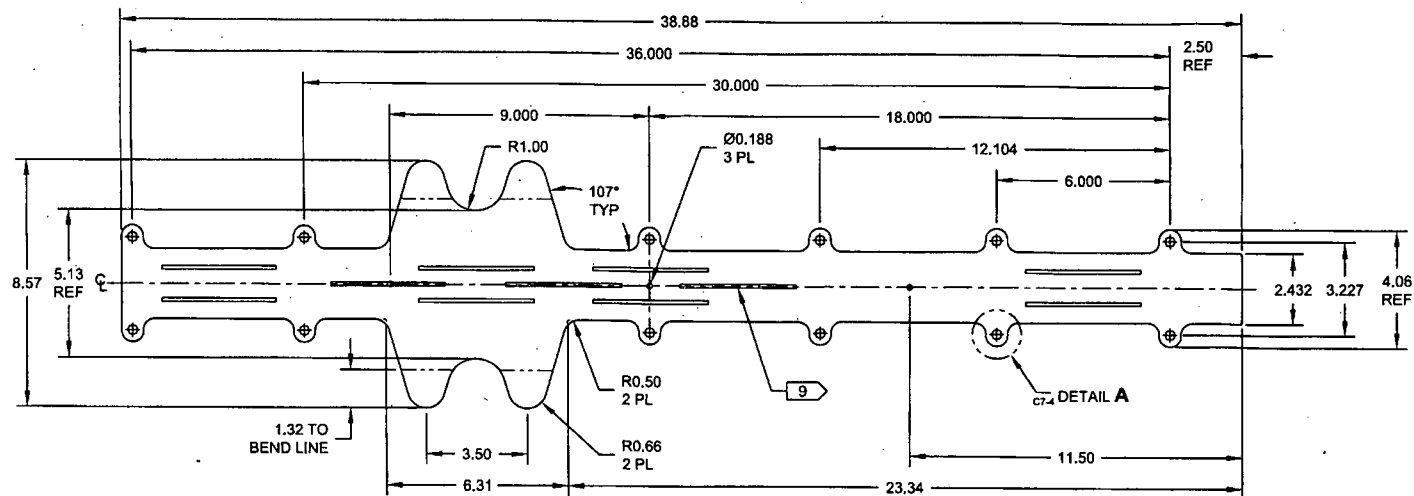
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 9) PARTS ARE SYMMETRIC ABOUT C

A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	J		
DRAWN	J		
CHECKED	P		
MFG. APPR.	D		
APPROVED	19		
DE APPR.	#		
DATE	10.04.20		

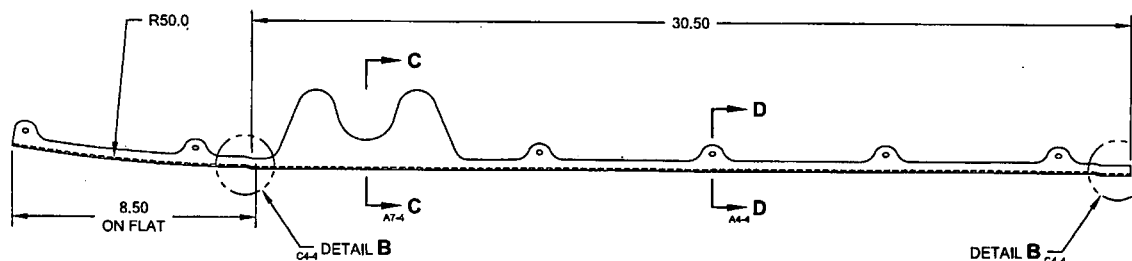
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095
REV. A
SHEET 1 OF 4
TITLE WEARPLATE
SCALE NTS

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D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1F/3F NOTES:

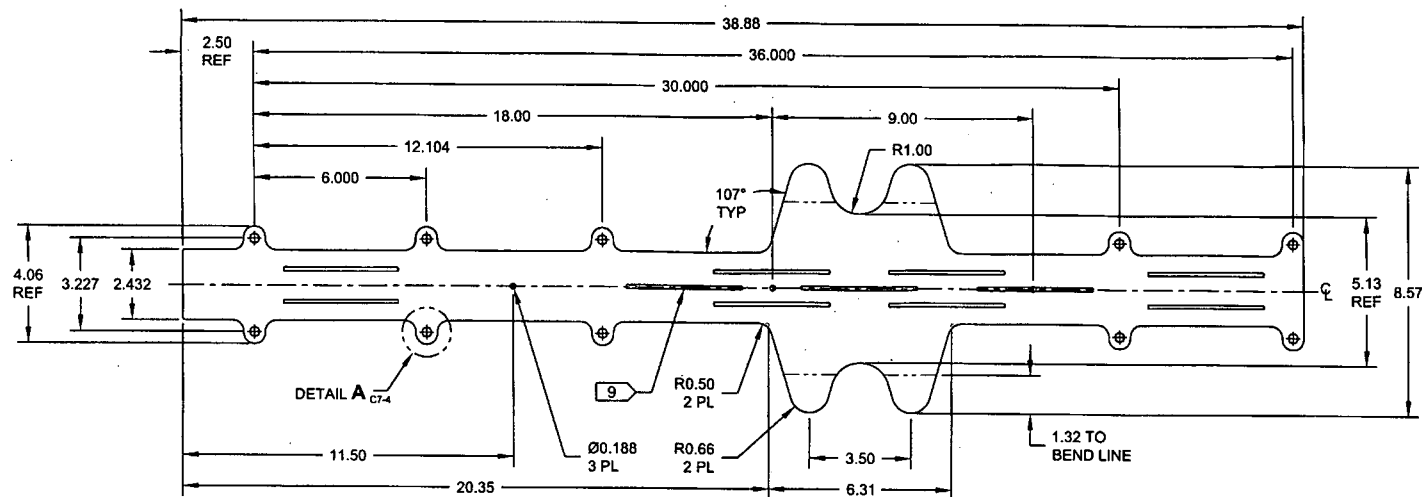
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL
WELD AFTER BENDING AS ILLUSTRATED PER DT8308
- 10) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4095 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD

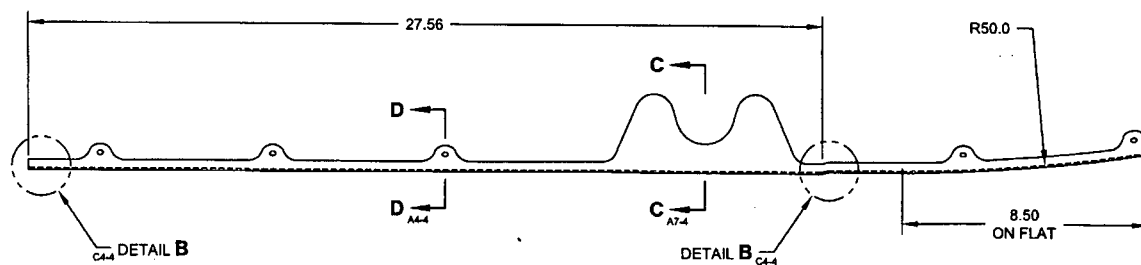
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RELEASED
2010-08-07

58138



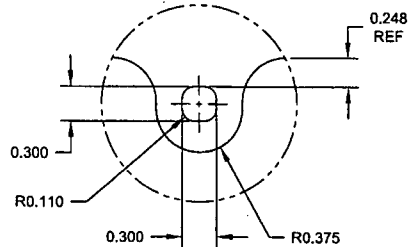
D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

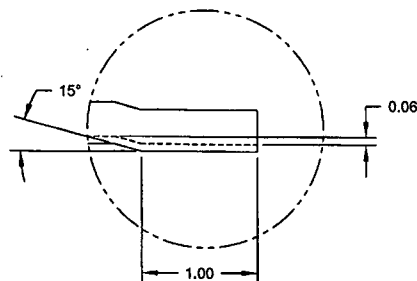
58138
RELEASED
2010-09-07
VMD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



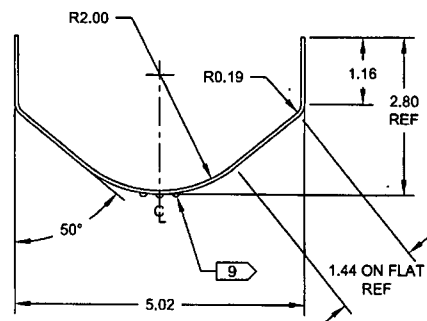
DETAIL A: TAB DETAIL

SCALE 4X
C3-2
C6-3



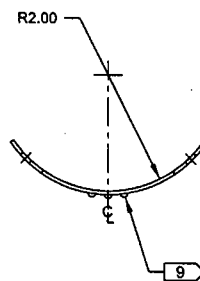
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-2
B5-2
B4-3
B7-3



SECTION C-C

SCALE 2X
B5-2
B4-3



SECTION D-D

SCALE 2X

58138

RELEASED
2010-09-07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Location/Lot Activity

October 7, 2010 1:34:21 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 58138 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D4095-043 / Wearplate Assembly	Main Warehouse ENG	58164	FAUT01		2.0000		2.0000		
					4/27/10	-2.0000	58138	-2.0000		-\$125.09
								-2.0000		-\$125.09
WIP Receipt	D4095-043 / Wearplate Assembly	Main Warehouse ENG	58138	FAUT01		0.0000		0.0000		
					4/27/10	2.0000	58138	2.0000		\$125.09
								2.0000		\$125.09

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